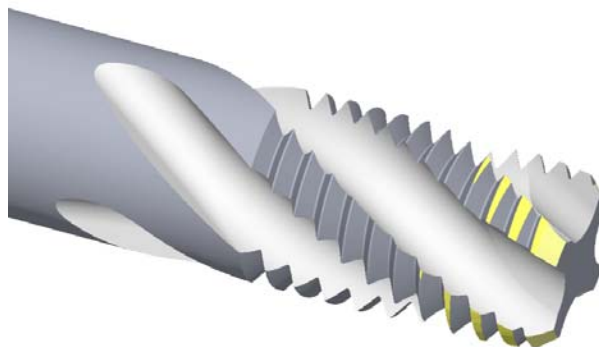


















Tap M16 Z4

A10-020

In the manufacturing cycle is included the dressing cycle for the conventional wheel for fluting and threadfinishing. An inverse calculation for the flutewheelshape based on graphical input of the fluteform is available.



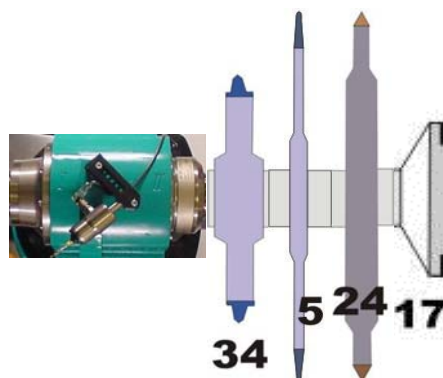
1. Cycletime for Production

Tool specifications								
M16, Length 25 mm, flutelength 55, Helix 30°								
Material HSS								
Operations								
Flute 1								
Gashing								
chamfer 1								
chamfer 2								
Thread rough								
Thread fin.								
dress flute								
dress thread								
Feed [mm/Min]	1000	180	200	200	1400	1400	100	100
Power [kW]	4	2	1	1	1	1	1	1
Cutting feed [m/s]	46	40	32	32	48	48	24	24
Used wheels								
Grinding time [s]	215	85	94	94	205	201	40	40
Total cycle time	16 Min 14							

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

34 Ø175 DXF A120
17 Ø125 12A2 B126
5 Ø150 14E1 A120
24 Ø125 14E1 A220



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, dressing unit
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5

responsible engineer: OP,20.5.08

www.schneeberger.ch

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